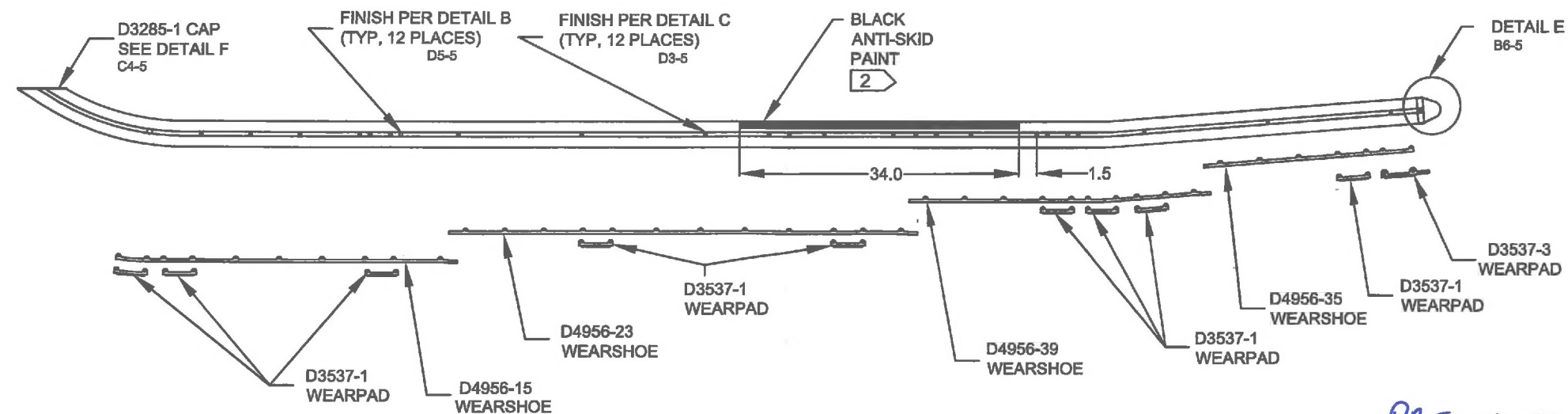
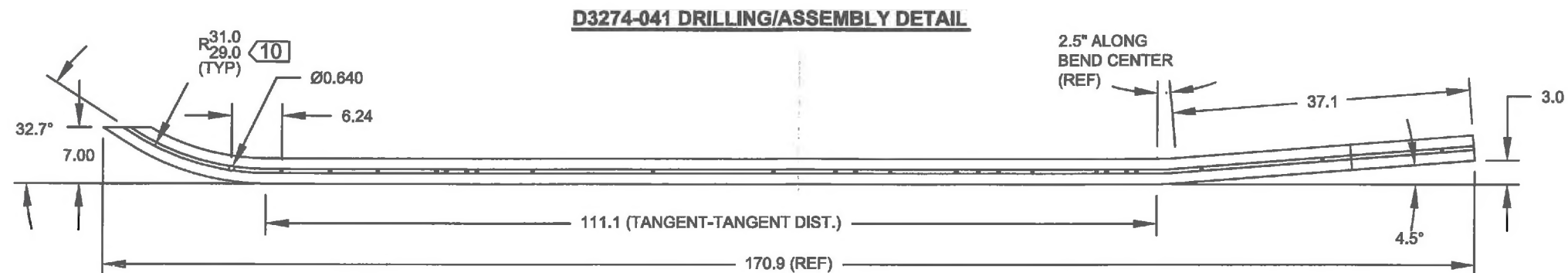
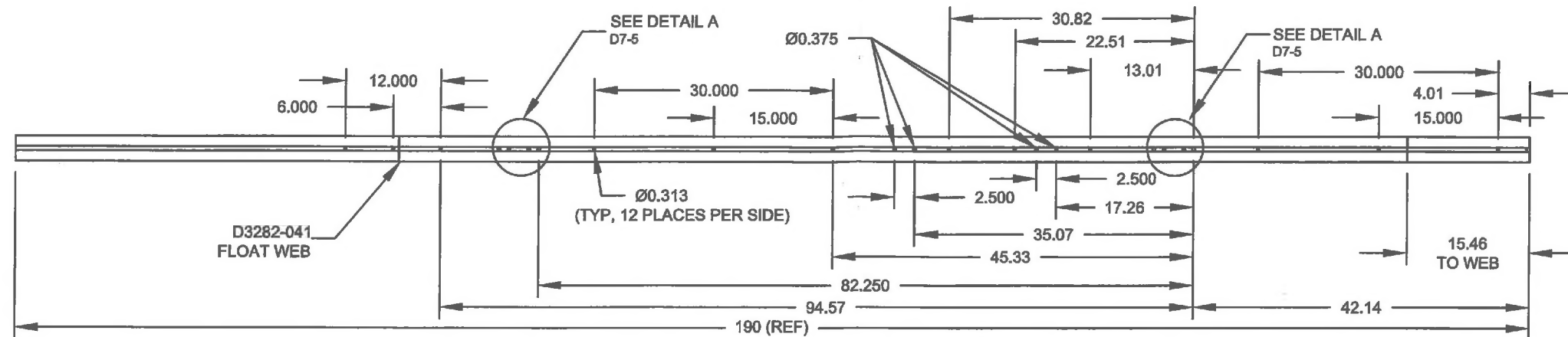


Table with 5 columns: Qty -041, Qty -043, Qty -045, Part Number, Description. Rows include SKIDTUBE ASSEMBLY, EXTRUSION, AFT CAP, CROSS BOLT SPACER, FLOAT WEB, CAP, RING, NUT PLATE, WEARPAD, WASHER, WEARSHOE, INSERT, BOLT, WASHER, RIVET, and SCREW.


GENERAL NOTES:

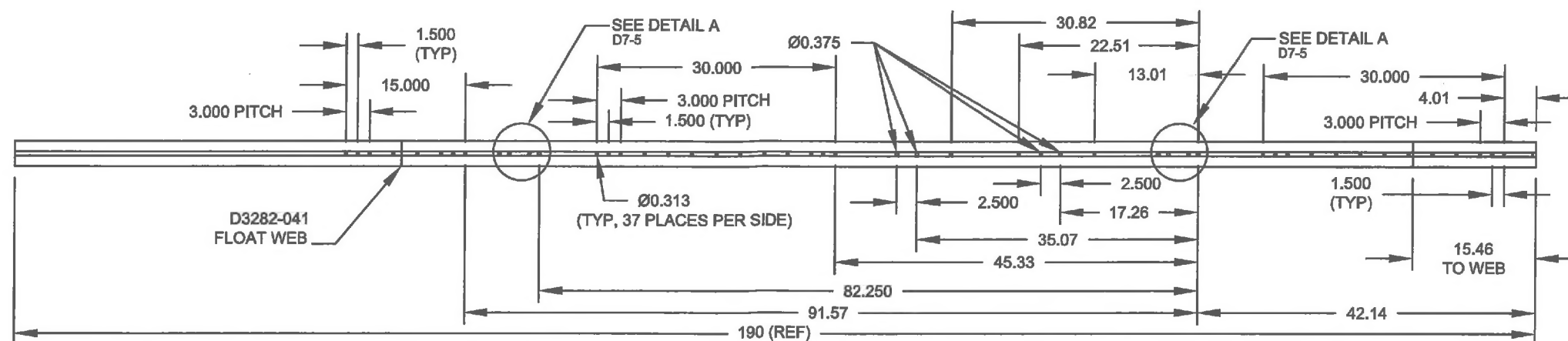
- 1. MATERIAL: N/A
- 2. FINISH:
 - ON -041/-043: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART QSI 005 4.2 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - ON -045: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER QSI 005 4.2.1 PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4. UNITS: INCHES UNLESS OTHERWISE NOTED
- 5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6. IDENTIFICATION: N/A
- 7. WEIGHT: FOR -041/-043 = 37.5 LBS FOR -045 = 33.4 LBS
- 8. WELDING TO BE DONE PER DART QSI 004.
- 9. ALL HOLES DRILLED ON CENTERLINES.
- 10. DAMAGE TOLERANCE ON FWD BEND: THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291. ON -045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARPLATES.
- 13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.
- 14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

Table with 4 columns: REV., DESCRIPTION, BY, DATE. Includes revision history and a title block for DART AEROSPACE USA, INC.

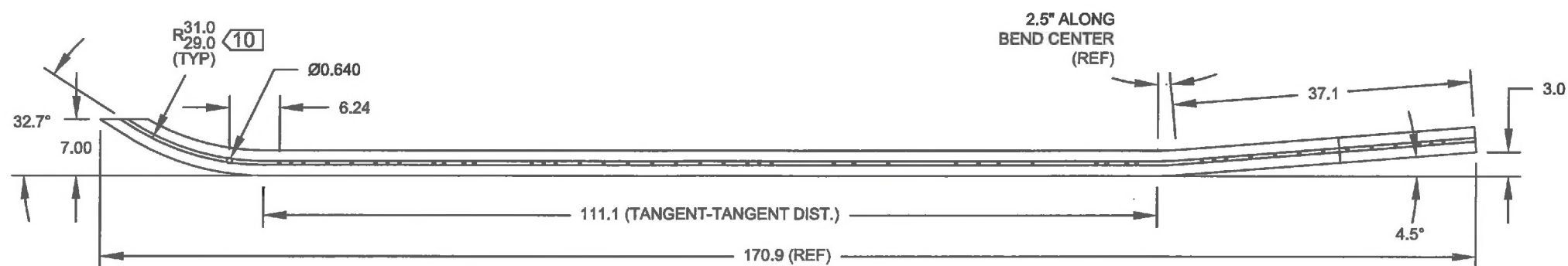


PRELIMINARY # 2015.05.16

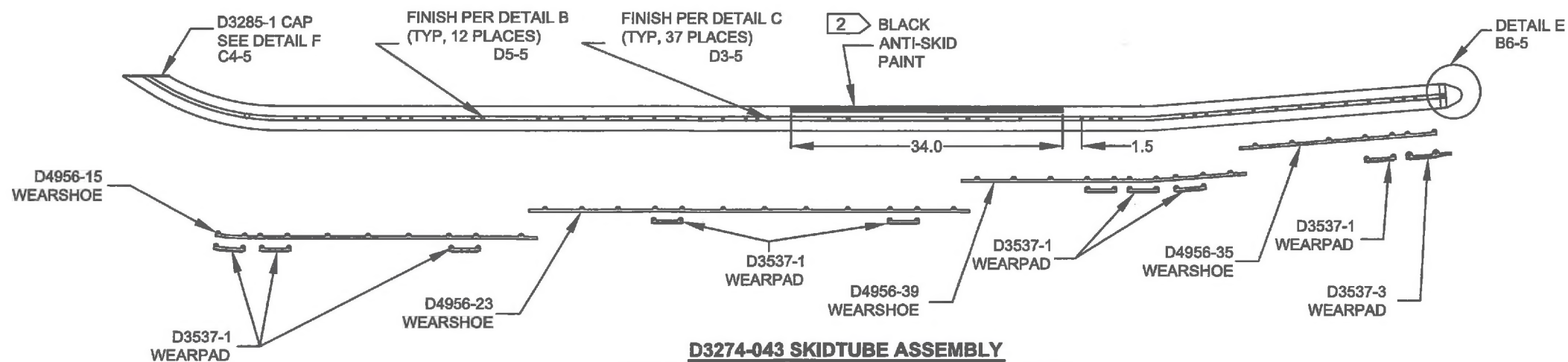
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 2 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC	
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D3274-043 DRILLING/ASSEMBLY DETAIL



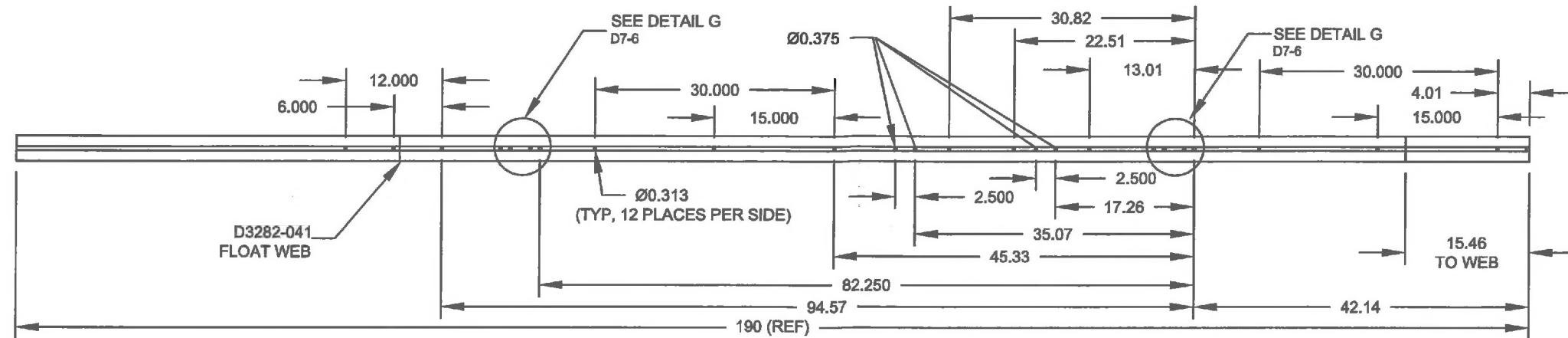
D3274-043 BEND/DRILLING DETAIL



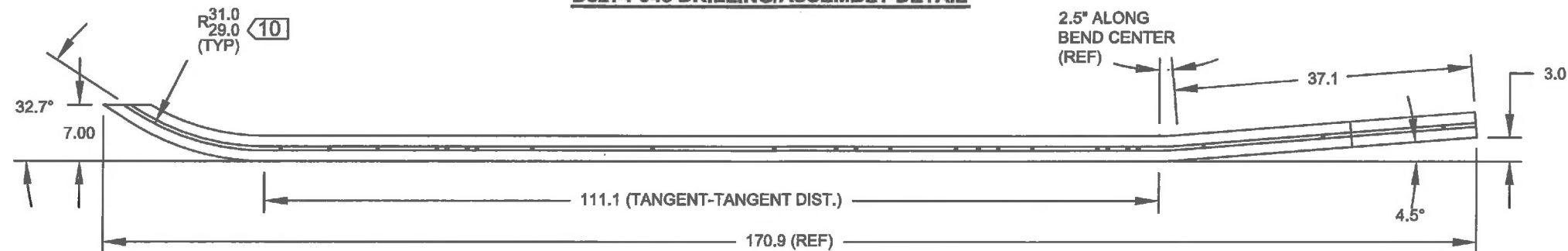
**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

PRELIMINARY 2016.05.16

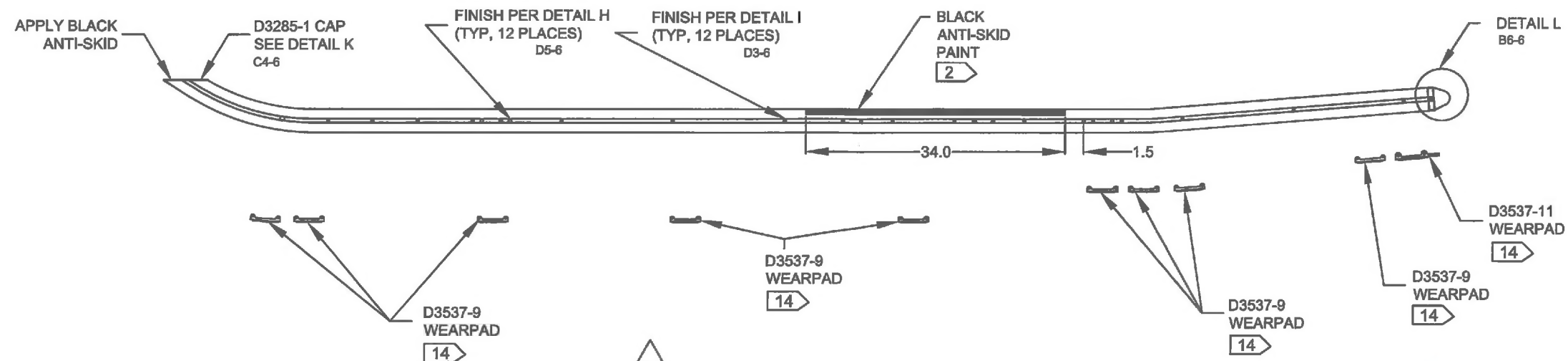
DESIGN	CP	DART AEROSPACE USA, INC	
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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 3 OF 6
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D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL



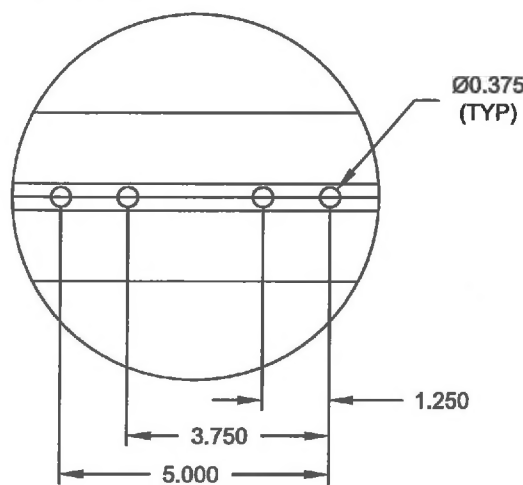
**G D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)**

PRELIMINARY 2016-05-16

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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 4 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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DETAIL A: DRILL DETAIL

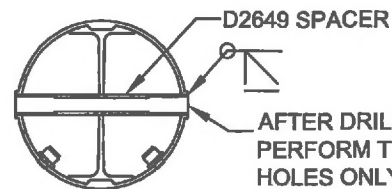
D6-2, D3-2, D5-3, D3-3



DETAIL B

B6-2, B5-3

FOR Ø0.375 HOLES ONLY



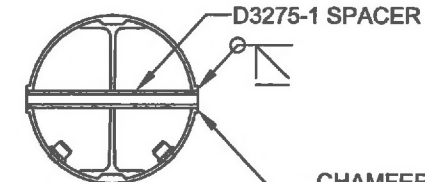
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C

B5-2, B4-3

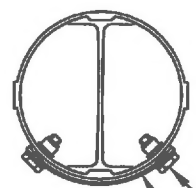
FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D

A4-2, A4-3

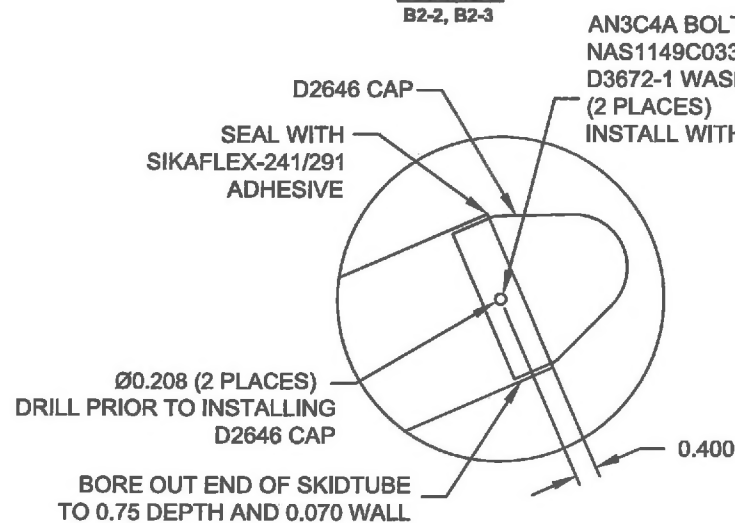


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(78 PLACES)

WEARSHOE/WEARPAD (REF)

DETAIL E

B2-2, B2-3

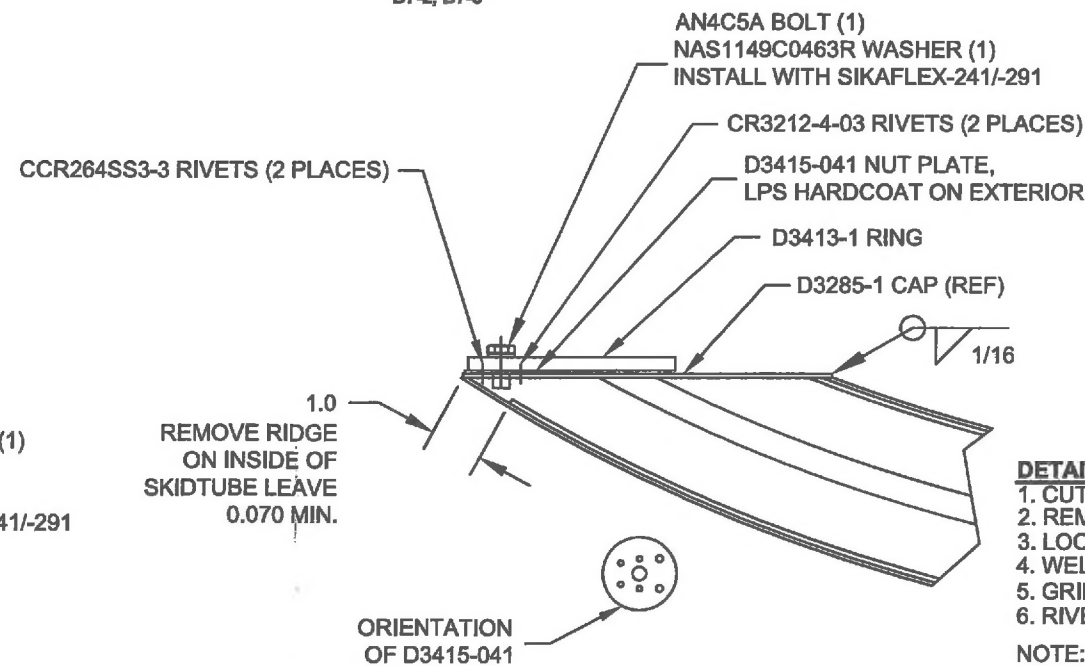


DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL

B7-2, B7-3



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

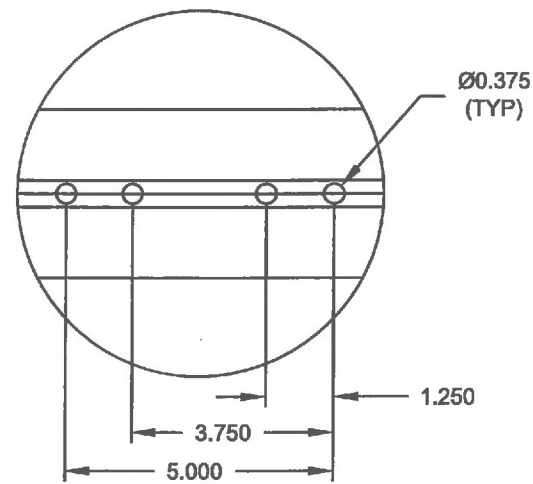
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-041/-043 DETAILS

PRELIMINARY # 2016-05-16

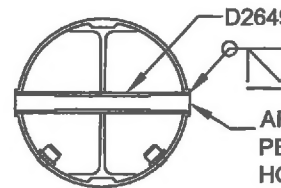
DESIGN	CP	DART AEROSPACE USA, INC	
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DETAIL G: DRILL DETAIL
D6-4, D3-4



DETAIL H
B6-4

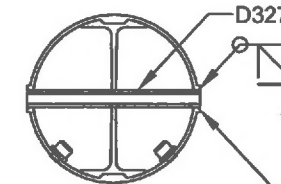
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

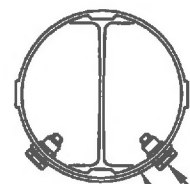
DETAIL I
B5-4

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

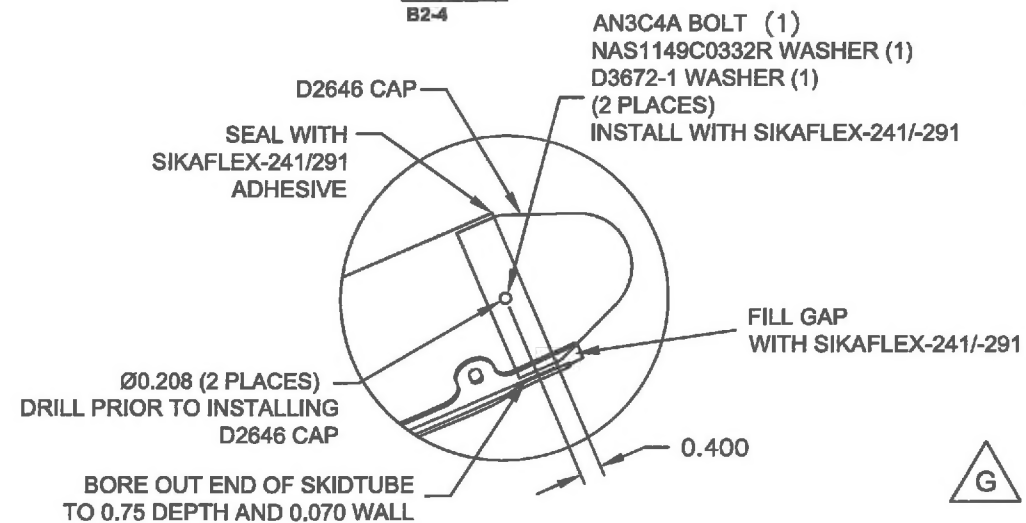
DETAIL J
A4-4



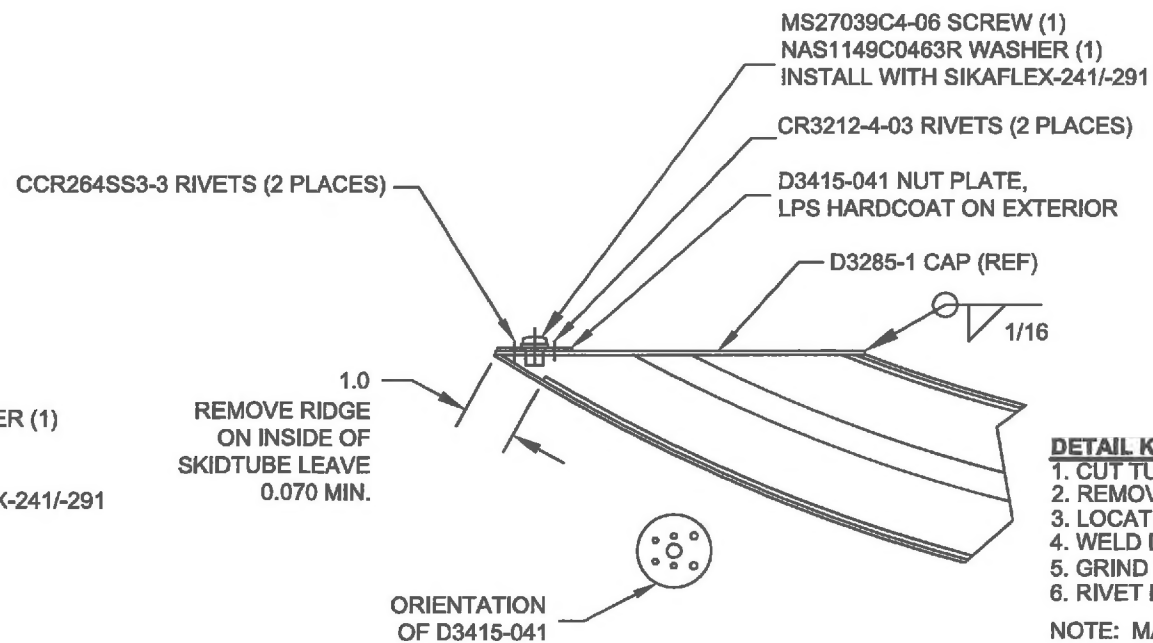
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(40 PLACES)

WEARPAD (REF)

DETAIL L
B2-4



DETAIL K: END FINISHING DETAIL
B7-4



DETAIL K NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH



-045 DETAILS

PRELIMINARY # 206-05.16

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DE APPR.		SKIDTUBE ASSEMBLY	NTS
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